

PROJECT TITLE : PROCESS ASSURANCE
PERIOD COVERED : August 1 - August 31 1981
WRITTEN BY : Bel-T. (THB)

1. AccuRay - Tobacco Weights (1 and 2)

In a meeting, which took place in Neuchâtel on August 20 with representatives of FTR's Production Department and Quality Assurance Services, the following decisions were taken:

The new specified tobacco weights will be decreased by 2 % for all cigarettes produced in FTR, except the Marlboro family which is involved in the 3-month PME industrial test.

The lower mean weight limit will be fixed at 0,5 % instead of 2,5 %.

The lower limit of the cigarette rod (reject point) will be fixed at - 7,5 % of the new specified tobacco weight.

The FDC Fraction Defective Control will remain at 0,5 %.

This means, in practice, that the effective tobacco weight will change very little or not at all, compared with the previous situation.

The only real consequence will be an increased amount of light weight rejects $> 0,5$ %, especially for cigarettes with a low tobacco weight. For these brands, FTR will carry out special checks on the differences (physical and analytical parameters) between the cigarettes of the mean weight and those near the reject point.

The reason for this modification in FTR is the fact that the range in tobacco weights, between the lightest and the heaviest cigarette, is great (500 to 1100 mg). In the past, it was not possible to realize tobacco savings with AccuRay on brands with a low tobacco weight, as a standard deviation on the cigarette maker of 15-17 mg would have been required.

Quality-wise, the new system has the advantage of

producing a mean weight variation in a range of 0,5 % only, compared with the previous 2,5 %, regardless of whether the cigarette had been produced on a good or on a bad cigarette maker.

A graph showing the relationship between the specified tobacco weight-tobacco saving and the standard deviation was sent to all QA managers. It shows, for example, that the standard deviation of the maker must be at Z mg for a specified tobacco weight of X mg, if a tobacco saving of Y % is to be realized.

15. Quality Workshop (3)

The monthly report supplement, covering the month of June, has been sent to PME management and to the QA managers.

19. Quality Control Audit

The first parts of the questionnaire have been prepared in view of the second Quality Control Audit, which will be carried out in all production centers in autumn 1981.

- REFERENCES :
1. Modifications de spécifications
Grossen-E memo (August 1981)
 2. AccuRay: Relation between specified tobacco weight-tobacco saving-standard deviation
Bel-T memo to QA managers (August 1981)
 3. Quality workshop, monthly report supplement (August 1981)

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THB/caf/September 3, 1981

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